



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/17/2008 11:57:07 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

Job Number: 38034

Part Number: D2889

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

5 08/04/08  
used in w/o # 37947

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W. 8.04.10

08/04/10 JJ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order:

38034

Description: Crosstube Fwd

Part Number:

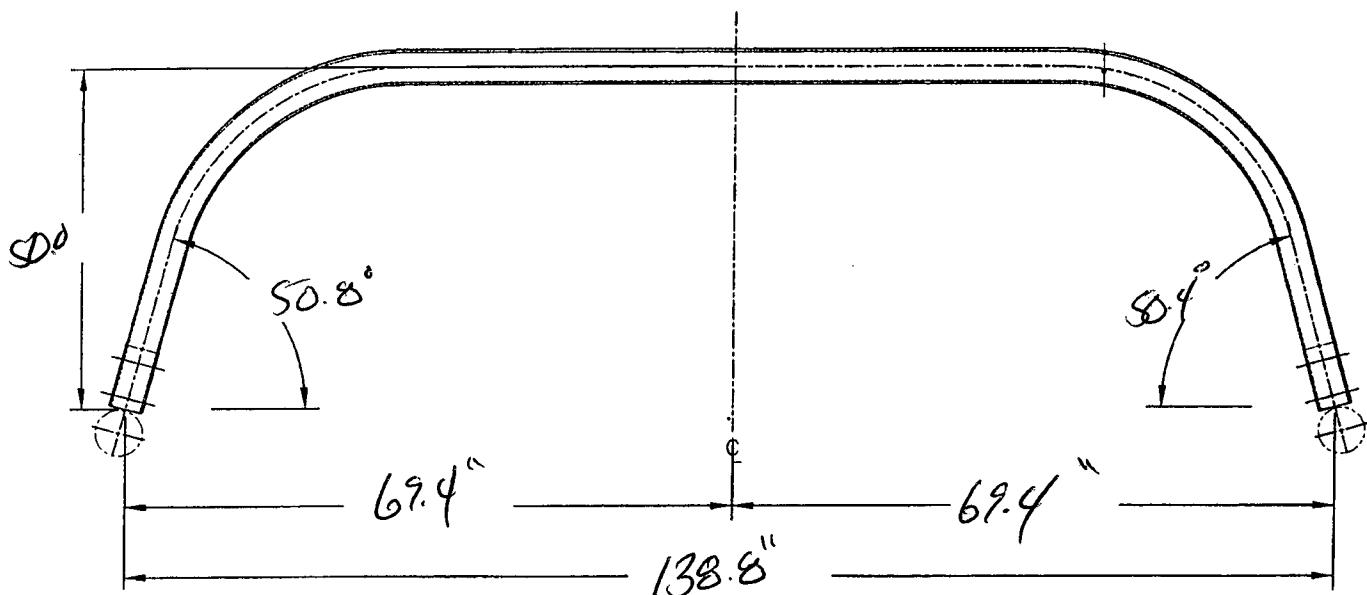
D2889

Inspection Dwg: D2889

Rev: B

Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



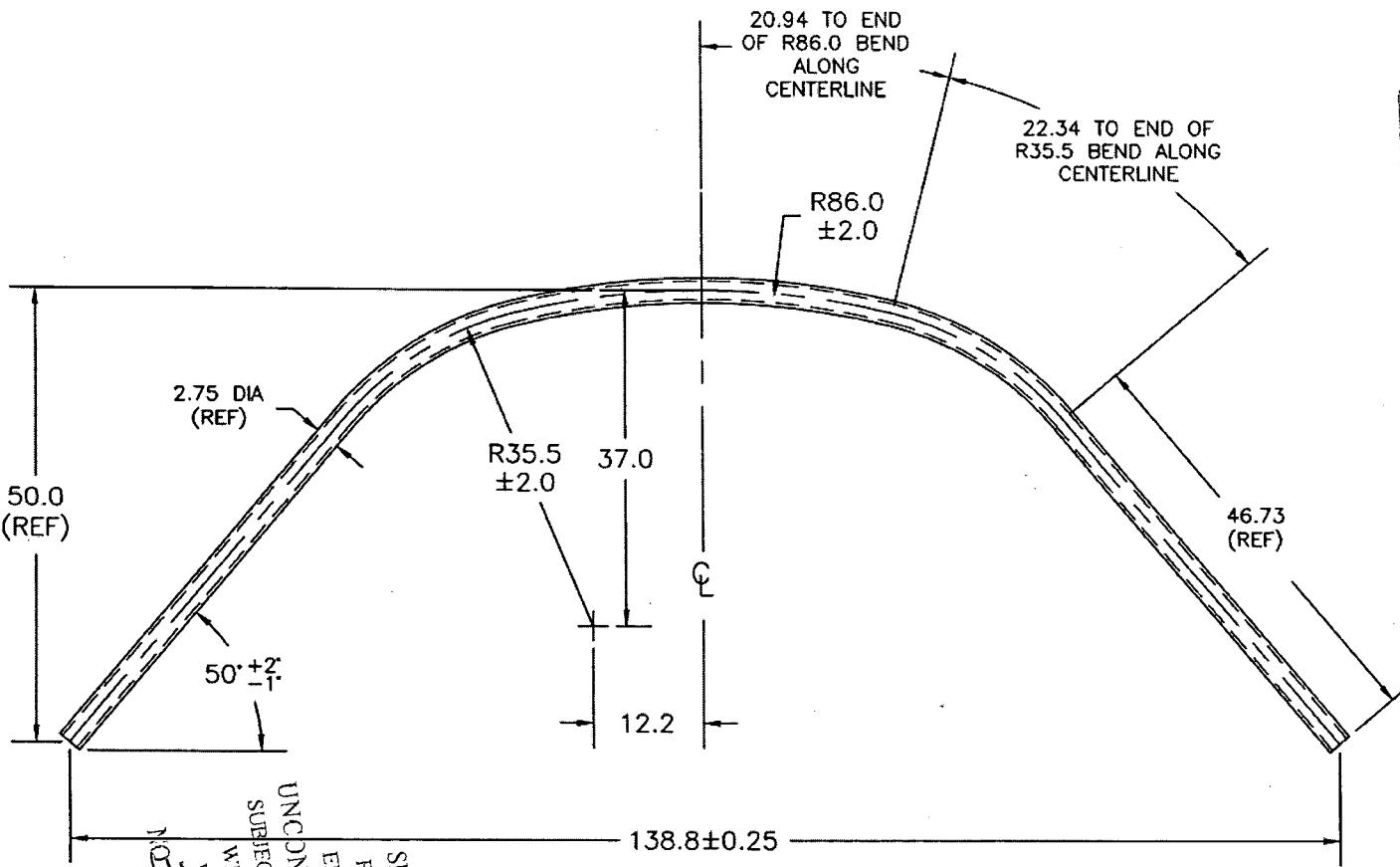
Comments
* used on w/lot 37947

QC15 Inspection	<i>5</i>
Date	08/04/08

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>✓</i>	<i>JM</i>

**DART**DART  
GARCO  
GARCO**RELEASED**  
02.10.28

DESIGN	DRAWN BY	DART AEROSPACE LTD		
		HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. B	SHEET 1 OF 1
		D2889		
DATE		TITLE		SCALE
02.10.18		FWD CROSSTUBE		1:20
A	99.05.21	NEW ISSUE		
B	02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES		

**NOTES**

- 1) MATERIAL: MANUFACTURE FROM D6005-180 ( $\phi 2.75$  OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 38034

Date: Friday, 04/04/2008 1:07:51 PM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FWD X-TUBE		
Job Number	: 38034			Part Number	: D2889		
Estimate Number	: 10006			Drawing Number	: D2889 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 04/04/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: 17/03/2008	Type	: LANDING GEAR	Due Date	: 04/04/2008	Qty:	1 Um: Each
Previous Run	: 36619						
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:A New Issue 05-10-25 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
3.0	CROSSTUBES	CROSSTUBES RESOURCE 1
		 <i>✓ 0604/11</i>
<b>Comment:</b> LANDING GEAR RESOURCE 1 1-Deburr and Polish		

Job Completion



REFERENCE ONLY *mr*